

SUCCESS STORY

- Revamp of Waldrich Siegen Roll and Yomis Roll Grinder – APP Indah Kiat Perawang -

Machine Details

OEM : Waldrich Siegen
Year of Installation : 1997
Model : WS III CPT 50 x 1400
Control System : OEM Waldrich Siegen
Bed Length : 14 000 mm
Max. Roll length : 12000 mm
Max. Roll diameter : 1500 mm
Max. Roll weight : 60 to

Description of Project:

The old spare parts of OEM control system were discontinued and the customer did not have the parts in their stock anymore. For this reason the customer decided to upgrade the control system with the new generation of drives, PLC and CNC control system. SBA offered an open system which could help the customer to maintain their control system easily. SBA got the order at the October of year 2009.

Condition before job :

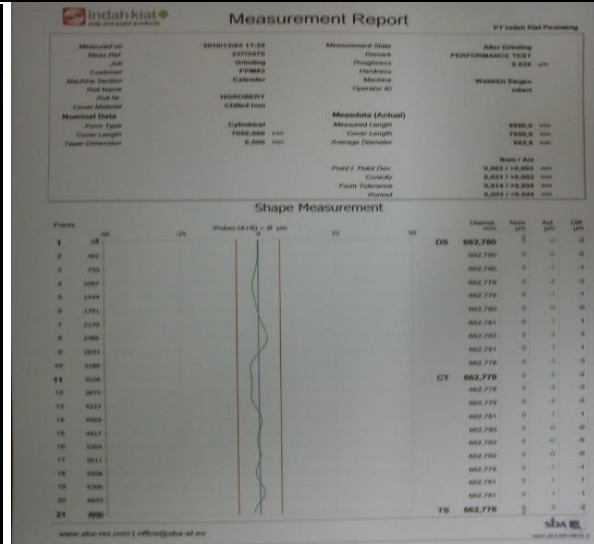
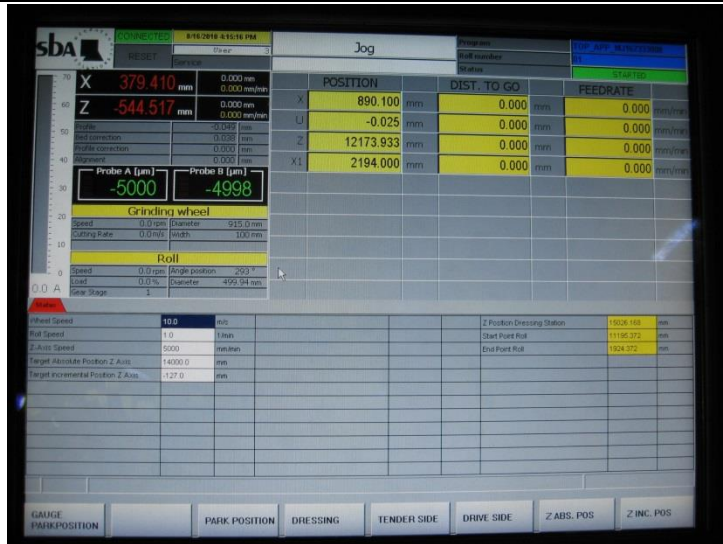


Scope of Supply :

- New control system including power components for the new CNC/PLC
- CPU with digital and analogue inputs and outputs integrated
- SINUMERIK 840D NC control including Software and operating software
- Operator panel
- Machine control board
- Electronic hand wheel for Z, X and C axis
- New control cabinet
- Stabilizer included into 840D power supply (net filter)
- Absolute linear encoder for the X axis
- New machine wiring for NCN, PLC components

Condition after finished job :





Customer was very satisfied with the grinding result.

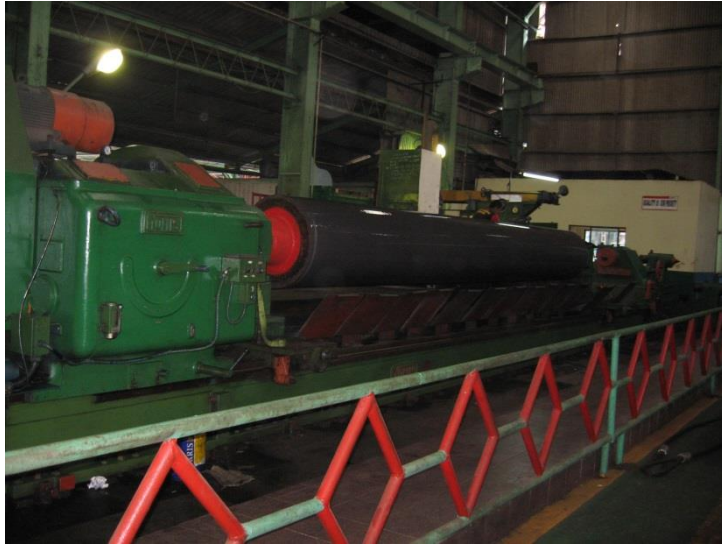
The result of the performance test shows following data:

- Point to point deviation : 3 micron
- Conicity : 2 micron
- Form tolerance : 5 micron
- Run out : 5 micron

Conclusion:

After this upgrade was done successfully SBA got another upgrade of Yomis grinding machine in May 2010.

Condition before job :



Scope of Supply :

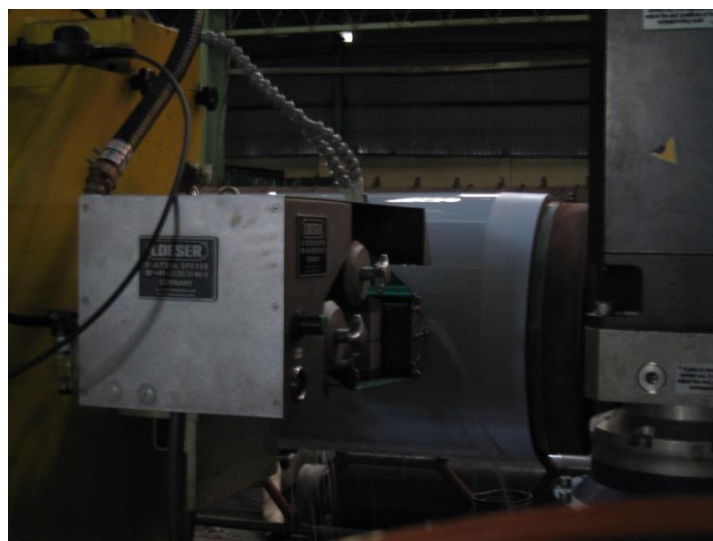
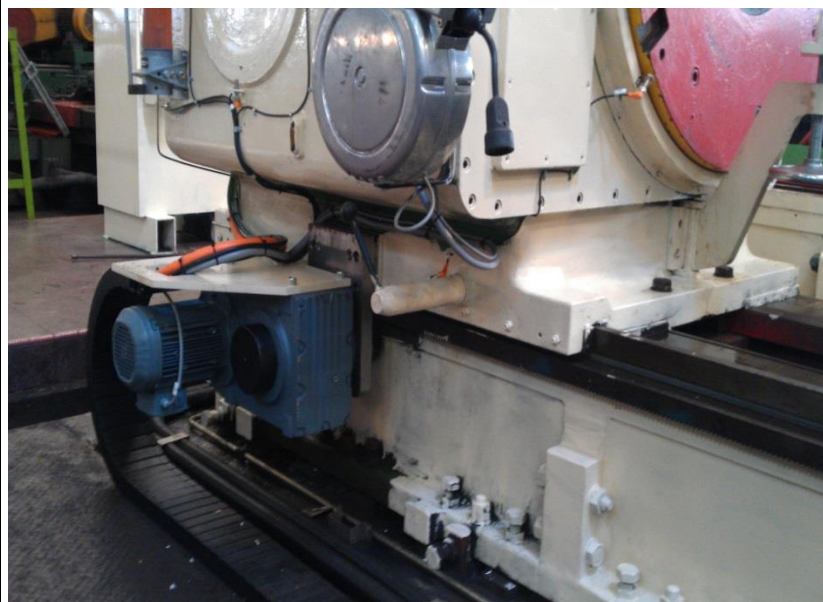
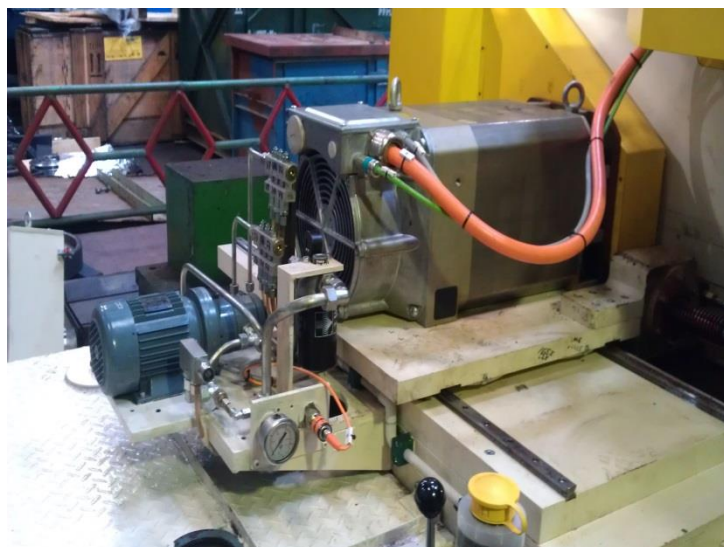
- New CNC control, new switchbox and cabling
- New Operator Panel
- New Linear Encoder for X axis
- New Servo motors and Servo Converters for Z and X axis
- New Main Spindle Motor and Controller for headstock drive
- New Motor Spindle for grinding wheel
- Automatic Balancing system
- New measuring device carbon fiber
- Belt Grinding device

SBA mechatronics GMBH, Weikersdorf am Steinfelde

- Spare parts package
- Leveling, Alignment and Re-scraping carriage bed
- New chuck and 1 m Cardan shaft
- New gear motor for head stock and tail stock traverse
- New hydraulic unit for steady rest upper parts
- New lubrication unit for tail stock
- New pump for grinding wheel shower coolant system
- New 3 set of grinding wheel flange (1 Normal, 1 Diamond, 1 CBN)
- New Venta Nip groove device include 1 set of blades and spacers
- New Super finishing device 8 inch
- Realignment during mechanical guarantee

Condition after finished job :





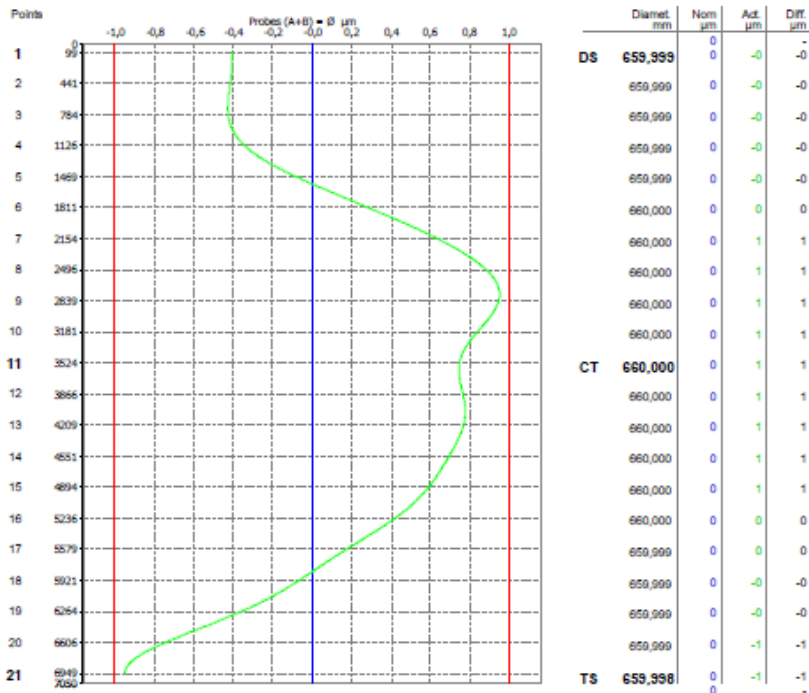


Measurement Report

Yomis

Measured on	2011/08/04 11:31	Measurement State	After Grinding
Meas Ref.	41/571	Remark	
Job	Operation Test	Roughness	μm
Customer	PFM2	Hardness	
Machine Section	Calendar	Machine	Machine name
Roll Name	Calendar	Operator ID	
Roll Nr.	JM		
Cover Material	Chilled iron		
Nominal Data		Measdata (Actual)	
Form Type		Measured Length	6850,1 mm
Cover Length	7050,000 mm	Cover Length	7050,0 mm
Taper Dimension	0,000 mm	Average Diameter	660,0 mm
		Nom / Act	
		Point t. Point Dev.	0,002 / +0,000 mm
		Conicity	0,017 / +0,001 mm
		Form Tolerance	0,002 / +0,002 mm
		Runout	0,002 / +0,030 mm

Shape Measurement



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The result of the performance test shows following data:

- Point to point deviation : 0 micron
- Conicity : 1 micron
- Form tolerance : 2 micron
- Run out : 30 micron